



Dart Aerospace Ltd.
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D5669-041

Job Sheet 188991



Part No: D5669-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/17/19

Job Tracking No:

Due Date: 2/14/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: TBD DWG D5669 REV.A IPP REV:A 18.07.23 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	2/14/19	2/14/19	0.00	0.00	Start Up Large Fab-5		LL
100	Large Fab	1 pcs	2/14/19	2/14/19	0.00	6.67	Large Fab 1		LL
110	QC	1 pcs	2/14/19	2/14/19	0.00	0.00	QC9	DAS 24 9-89	CPC
120	QC	1 pcs	2/14/19	2/14/19	0.00	0.00	QC5		CPC
130	Powdercoat - 4 Black Sand - B4B	1 pcs	2/14/19	2/14/19	0.00	0.40	Powdercoat - 1 - B4B		BL 14-01-31
							Powdercoat - 2 - B4B		
							Powdercoat - 3 - B4B		
							Powdercoat - 4 - B4B		
135	QC	1 pcs	2/14/19	2/14/19	0.00	0.00	QC3		HL 19-1-31
140	HandFinish	1 pcs	2/14/19	2/14/19	0.00	0.80	HandFinish4		HL 14-0-501
150	QC	1 pcs	2/14/19	2/14/19	0.00	0.00	QC5		FEB 04 2019 68
160	Packaging	1 pcs	2/14/19	2/14/19	0.00	0.00	Packaging3-2		FEB 04 2019 68
170	QC21-SA	1 Ea	2/14/19	2/14/19	0.00	0.00	QC21		FEB 04 2019 68

Part Op 100 - 1- Assemble ribs , weld as per dwg D5669 using DT9607A 2- Weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- Cut lid mesh as per dwg 4- Tack weld mesh on basket as per dwg
D5669 ***Cut out mesh where label plate goes in center off basket lid as per dwg. Make sure to place mesh correctly on
lid, check with label plate before tacking mesh*** **CUT OUT MESH ON TOP OF D2581 1.5" HIGH*** **DOUBLE
CHECK WITH A HANDLE*** 5- ****SCRIBE ID AS PER DWG NOTE 6 ON SHEET 1****
120 - ****SCRIBE ID AS PER DWG NOTE 6 ON SHEET 1****
130 - *** Mask holes as per note 9, sides of hinge and note 11 prior to powdercoat*** START TIME: 8:25 OVEN
TEMPERATURE: 375° FINISH TIME: 13:05 n 138997.
140 - 1- Assemble as per dwg 2- Mask data plate and apply wing walk on outside surface of mesh as per dwg and QSI
Wing Walk batch: (3:40)

Job BOM

007859

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	90-Start up Operation	5143339
D3914-1	Rib	2 pcs (2 ea)	90-Start up Operation	5145084
D4016-3	Hinge Half, Lid	3 pcs (3 ea)	90-Start up Operation	5110937
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea)	90-Start up Operation	5145630
D5670-1	Rib	4 pcs (4 ea)	90-Start up Operation	5146832
D5670-3	Rib	9 pcs (9 ea)	90-Start up Operation	5145898
D5672-1	Data Plate	1 pcs (1 ea)	90-Start up Operation	5133197
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	90-Start up Operation	5125258
AN3-14A	Bolt AN3-15A	4 Ea (4 ea)	140-HandFinish	5143225
AN3-16A	Bolt	2 Ea (2 ea)	140-HandFinish	5089276
AN5-17A	Bolt	2 Ea (2 ea)	140-HandFinish	5143682
D2530	Handle Weldment	1 pcs (1 ea)	140-HandFinish	5145894
D2535	Spring	2 pcs (2 ea)	140-HandFinish	5121157
D2537	Bushing	2 pcs (2 ea)	140-HandFinish	5123161
D3953-17	Gas Spring Spacer	2 pcs (2 ea)	140-HandFinish	5135367
D3953-19	Gas Spring Bracket	2 pcs (2 ea)	140-HandFinish	5143335
MS21042L3	Nut	6 Ea (6 ea)	140-HandFinish	5094852
MS21042L5	Nut	2 Ea (2 ea)	140-HandFinish	5142139
NAS1149F0332P	Washer	8 Ea (8 ea)	140-HandFinish	5131693
NAS1149F0563P	Washer	2 Ea (2 ea)	140-HandFinish	5098031

Job Allocations

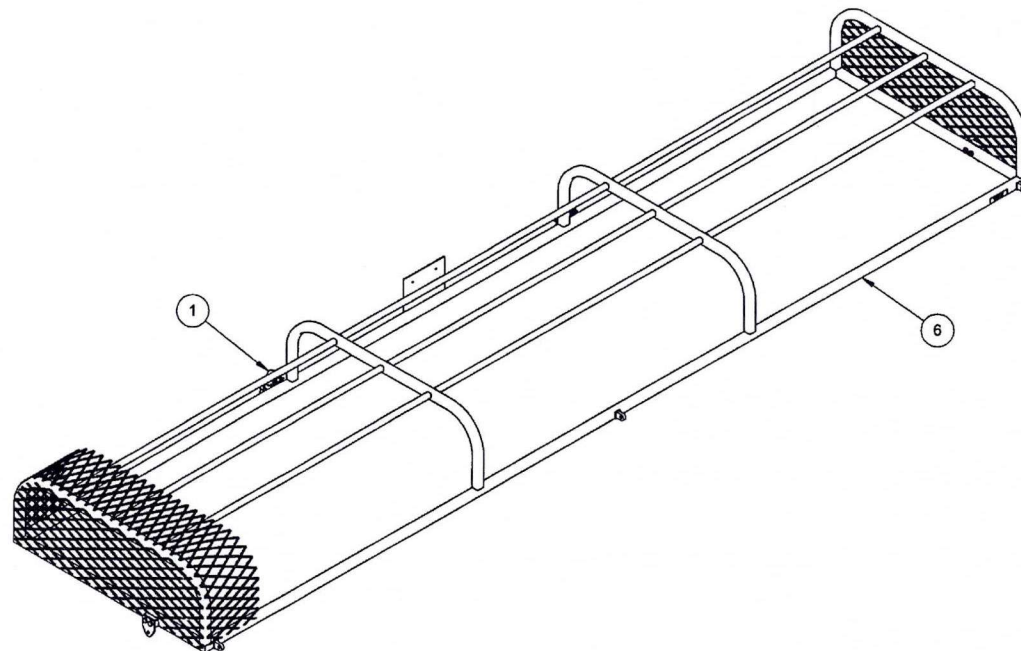
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	61	0
	D3914-1	2	12	0
	D4016-3	3	171	0
	D4035-043	2	14	0
	D5670-1	4	4	0
	D5670-3	9	0	0
	D5672-1	1	8	0
140-HandFinish	M304EX0.75-16F	32	1,292	0
	AN3-14A	4	275	0
	AN3-16A	2	45	0
	AN5-17A	2	129	0
	D2530	1	5	0
	D2535	2	19	0
	D2537	2	0	0
	D3953-17	2	27	0
	D3953-19	2	50	0
	MS21042L3	6	2,207	0
	MS21042L5	2	294	0
	NAS1149F0332P	8	2,259	0
	NAS1149F0563P	2	544	0

Part Specifications

Specifications could not be found.

007818

ITEM	QTY.	P/N	DESCRIPTION
	X	D5669-041	LONG BASKET LID ASSY
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
3	2	D2537	BUSHING
4	2	D3953-17	GAS SPRING SPACER
5	2	D3953-19	GAS SPRING BRACKET
6	1	D5669-043	WELDMENT LID ASSY
7	2	AN3-16A	BOLT
8	4	AN3-14A	BOLT
9	2	AN5-17A	BOLT
10	6	MS21042L3	NUT, SELF-LOCKING
11	2	MS21042L5	NUT, SELF-LOCKING
12	8	NAS1149F0332P	WASHER
13	2	NAS1149F0563P	WASHER



D5669-041 LONG BASKET LID ASSY
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED

2018 SEP 06

ECN 18-716

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART P/N AND S/N USING 0.13 (MINIMUM) HIGH LETTERING PER QSI 044 6.4
- 7) WEIGHT: 41.82 lbs APPROX

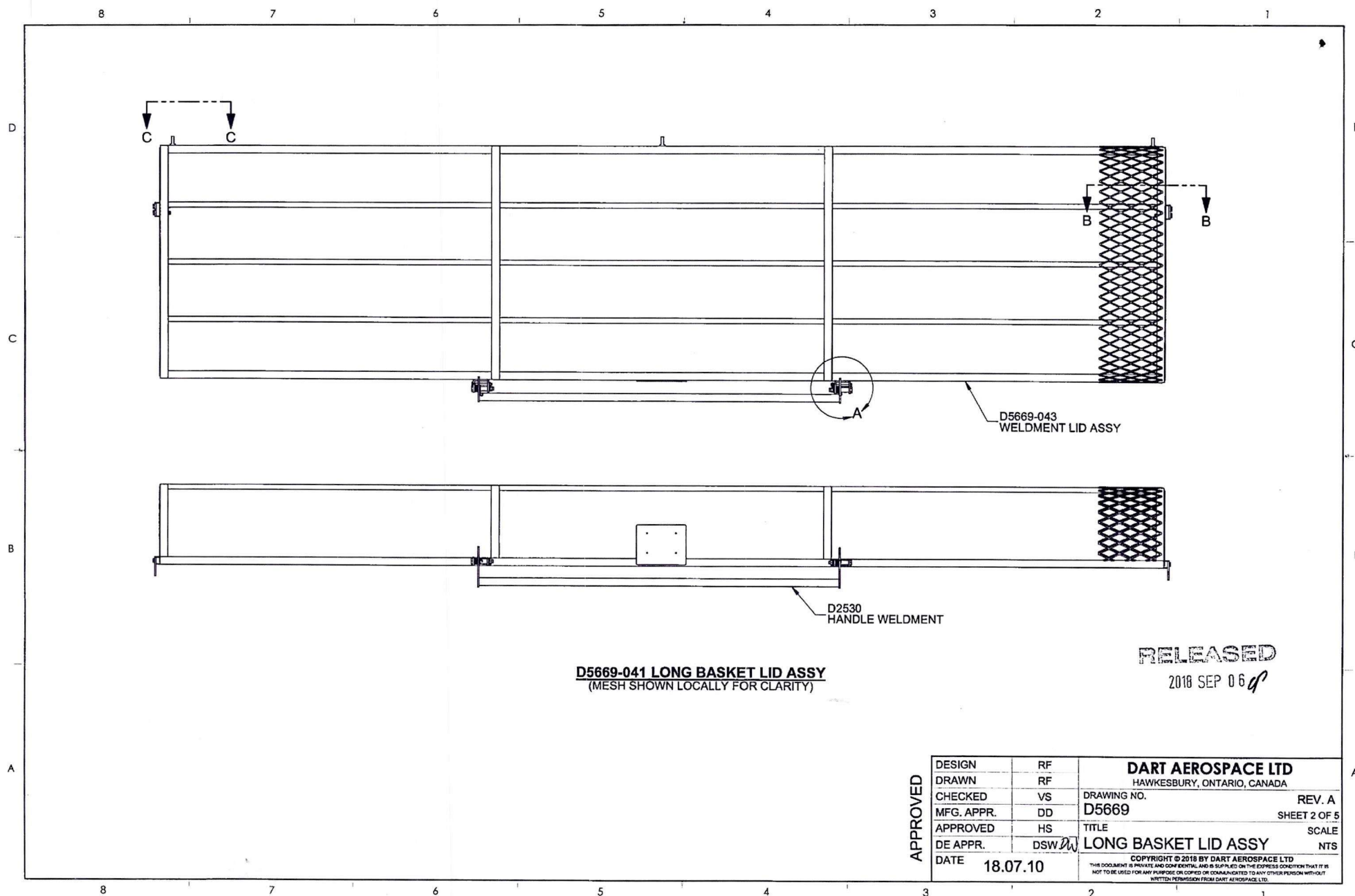
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DESIGN	RF		
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	DD		
APPROVED	HS		
DE APPR.	DSW (X)		
DATE	18.07.10		

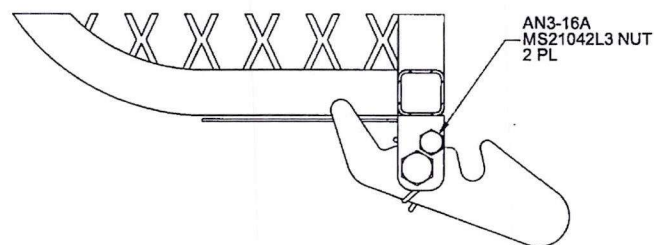
APPROVED

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HAWKESBURY, ONTARIO, CANADA

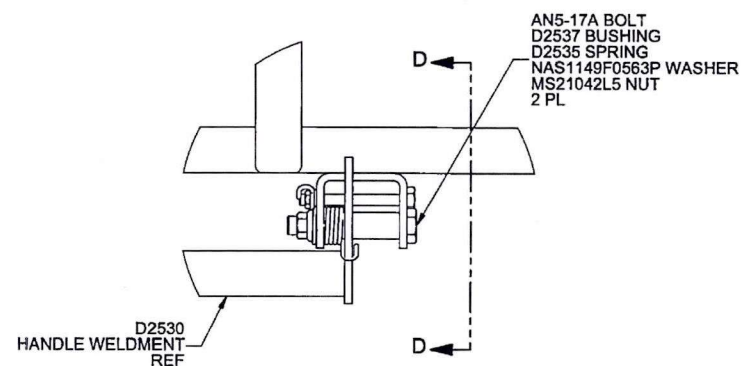
DRAWING NO. **D5669** REV. A
SHEET 1 OF 5
TITLE **LONG BASKET LID ASSY** SCALE NTS

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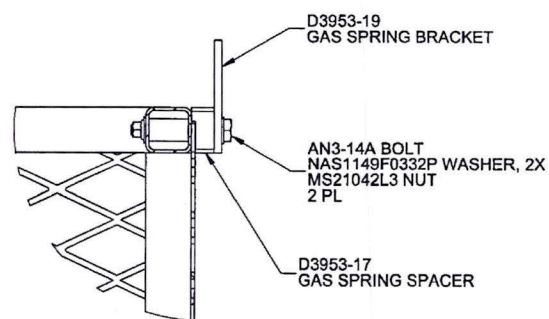




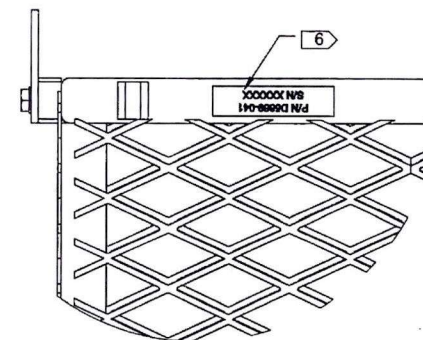
SECTION D-D
SCALE 2X



DETAIL A
SCALE 2X
2 PL



SECTION B-B
SCALE 2X
2 PL



VIEW C-C
SCALE 2X

RELEASED

2018 SEP 06

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5669	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DSW	LONG BASKET LID ASSY	NTS
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Container No: S149310



Part: D5669-041

Job No: 188991

Serial No/Batch: S149310

Revision: A

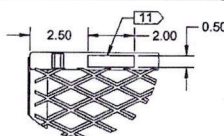
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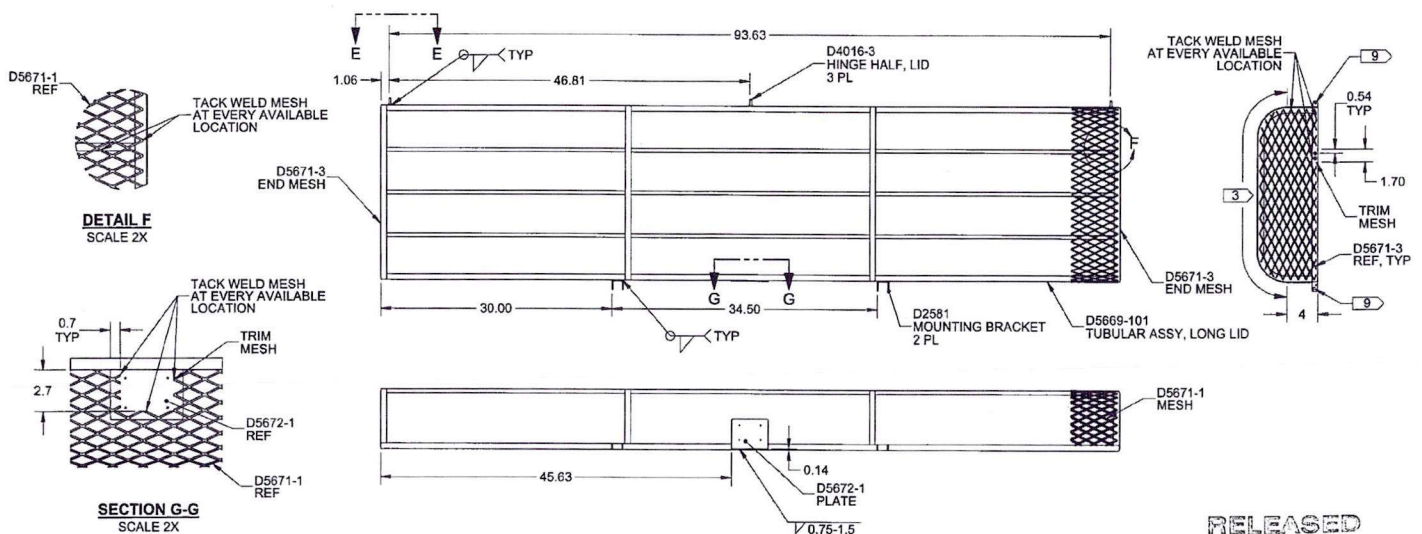
Instructions:

Date: 01/30/19

ITEM	QTY.	P/N	DESCRIPTION
	X	D5669-043	WELDMENT LID ASSY
1	2	D2581	MOUNTING BRACKET
2	3	D4016-3	HINGE HALF, LID
3	1	D5669-101	TUBULAR ASSY, LONG LID
4	1	D5671-1	MESH
5	2	D5671-3	END MESH
6	1	D5672-1	PLATE



VIEW E-E
SCALE 4X



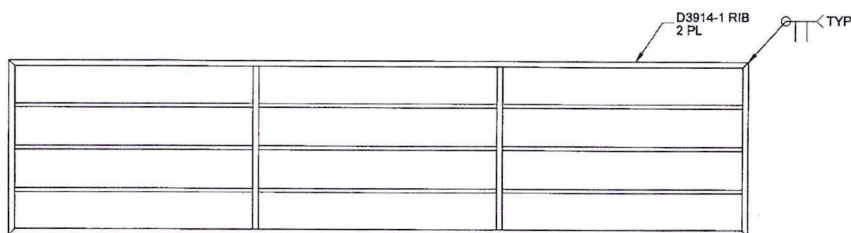
D5669-043 WELDMENT LID ASSY
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2018 SEP 06

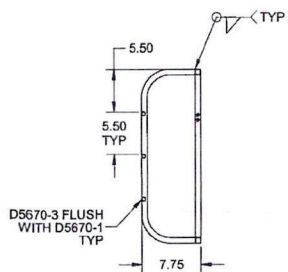
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) ANTI-SKID: APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) WEIGHT: 36.37 lbs APPROX
 - 9) MASK HOLES PRIOR TO FINISHING
 - 10) WELD PER DART QSI 004
 - 11) MASK THIS AREA PRIOR TO FINISH

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	DRAWN	RF		
	CHECKED	VS	DRAWING NO.	REV. A
	MFG. APPR.	DD	D5669	SHEET 4 OF 5
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DSW	LONG BASKET LID ASSY	NTS
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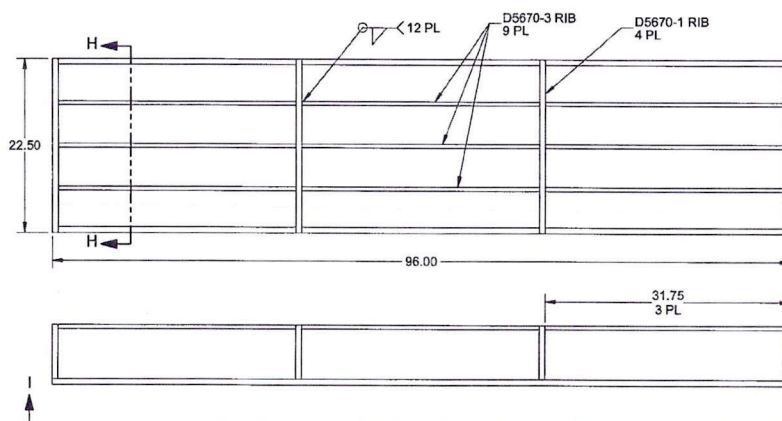
ITEM	QTY	P/N	DESCRIPTION
	X	D5669-101	TUBULAR ASSY, LONG LID
1	2	D3914-1	RIB
2	2	D4035-043	BASKET LID RIB ASSY, AFT
3	4	D5670-1	RIB
4	9	D5670-3	RIB



VIEW H



SECTION H-H



RELEASED
2018 SEP 06

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 19.49 lbs
 - 8) TOLERANCE FOR XX XX DIMENSIONS ± 0.06 FOR D5669-101
 - 9) WELD PER DART QSI 004

D5669-101 TUBULAR ASSY, LONG LID

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APPROVED	HS	
DE APPR.	DSW	LONG BASKET LID ASSY
DATE	18.07.10	